



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5522-1
Job Sheet 188589



Part No: D5522-1

Job Qty: 10 pcs

Part Name: Oil Drain Valve Mount



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/11/19

Job Tracking No:

Due Date: 2/15/19

Created By: Jesse White

Type: SOLD

Description:

Note: D5522 REV.C IPP REV:A 17.05.29 NEW ISSUE DD VERF:JFS IPP REV:B 17.11.17 MODIFY PROCESS TO MATCH INTUITIVE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	10 pcs	2/15/19	2/15/19	0.00	1.00	Bandsaw - 1		JS 19-01-23
110	HAAS 5 Axis - B4B	10 pcs	2/15/19	2/15/19	0.00	5.00	HAAS - 5 - B4B		JS 19-02-21
120	QC 2	10 pcs	2/15/19	2/15/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		JS 19-02-21
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 38		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		



Container No: S147265



Part: D5522 - 1

Job No: 188589

Serial No/Batch: S147265

Revision: C

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 01/23/19

HS

130	QC 8	10 pcs	2/15/19	0.00 0.00	QC 2 - 63	
					QC 2 - 8	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	5 C.L. 19-02-26
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 38	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	DAS
140	Small Fab - 2 - B4B	10 pcs	2/15/19	0.00 1.00	Small Fab - 1 - B4B	58 MAR 06 2019
					Small Fab - 2 - B4B	9-89
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
150	QC 5	10 pcs	2/15/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 38	
					QC 5 - 42	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	DAS
					QC 5 - 30	30
						9-89
160	Packaging 3-1 - Stock - B4B	10 pcs	2/15/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	DAS
					Packaging 3 - 9 - B4B	30
					Packaging 3 - 10 - B4B	9-89
					Packaging 3 - 11 - B4B	

				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
170	QC 21 - SA	10 pcs	2/15/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70

Part Op **100** - Bandsaw - Cut blanks at 3.63"
 Descriptions: **110** - HAAS CNC vertical machine #5 - 1-Machine D5522-1 as per Folio FB540 and Dwg D5522. 2-Deburr
120 - QC2- Inspect parts off machine FAI/FAIB
130 - QC8- Inspect parts - second check
140 - Small Fab - USE ULTRA SONIC TO CLEAN D5522-1 PART MUST BE DRY INSTALL PLASTIC PUSH-ON CAPS
150 - QC5- Inspect part completeness to step on W/O ***BEFORE PUTTING THE CAPS VERIFY IF THE PART IS CLEAN INSIDE***
160 - Identify as per dwg & Stock Location: _____
170 - QC21- Final Inspection - Work Order Release

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M303B1.500X3.500	303 Bar 1.500" X 3.500"	3 ft (.3 ea)	100-Bandsaw - 1	5119 738 FM 137651

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M303B1.500X3.500	3	7	0

Part Specifications
Specifications could not be found.



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D5522-1**Job Sheet 188589****Part No:** D5522-1**Job Qty:** 10 ea**Part Name:** Oil Drain Valve Mount**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 1/11/19**Job Tracking No:****Due Date:** 2/15/19**Created By:** Jesse White**Type:** SOLD**Description:**

Note: D5522 REV:C IPP REV:A 17.05.29 NEW ISSUE DD VERF:JFS IPP REV:B 17.11.17 MODIFY PROCESS TO MATCH INTUITIVE DD VERF:JFS

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		2/15/19	0.00	0.00	Start Up Machining-4		
100	Bandsaw	10 pcs		2/15/19	0.00	1.00	Bandsaw1		
110	CNC Vertical Machining	10 pcs		2/15/19	0.00	5.00	HAAS 5 Axis		
120	QC	10 pcs		2/15/19	0.00	0.00	QC2 Machining-4		
130	QC	10 pcs		2/15/19	0.00	0.00	QC8 Machining-4		
140	Small Fab	10 pcs		2/15/19	0.00	1.00	Small Fab-5		
150	QC	10 pcs		2/15/19	0.00	0.00	QC5		
160	Packaging	10 pcs		2/15/19	0.00	0.00	Packaging3-2		
170	QC21-SA	10 Ea		2/15/19	0.00	0.00	QC21		

Part Op 100 - Cut blanks at 3.63"

Descriptions: 110 - 1-Machine D5522-1 as per Folio FB540 and Dwg D5522. 2-Deburr

120 - QC2- Inspect parts off machine FAI/FAIB

130 - QC8- Inspect parts - second check

140 - USE ULTRA SONIC TO CLEAN D5522-1 PART MUST BE DRY INSTALL PLASTIC PUSH-ON CAPS

150 - ***BEFORE PUTTING THE CAPS VERIFY IF THE PART IS CLEAN INSIDE***

160 - Identify as per dwg & Stock Location: _____

170 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M303B1.500X3.500	303 Bar 1.500" X 3.500"	3 ft (.3 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M303B1.500X3.500	3	7	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions		
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance		
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect		
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved		
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing		
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish		
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread		
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence		
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____					
Misidentified ☐	☐ Past Due						

DART AEROSPACE LTD		Work Order: 188.589
Description: Oil Drain valve Mount		Part Number: D5522-1
Inspection Dwg: D5522 Rev: C		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.45	+/- .030	3.451	✓		SL10	vern
2.35	+/- .030	2.351	✓			
3.35	+/- .030	3.351	✓			
2.00	+/- .030	2.001	✓			
1.25	+/- .030	1.2485	✓			
R.63	+/- .030	.630	✓		Rad gauge	
.94	+/- .030	.940	✓			
.80	+/- .030	.800	✓			
.80	+/- .030	.801	✓			
R.13	+/- .030	.130	✓		Rad gauge	
2.13	+/- .030	2.130	✓			
R.41	+/- .030	.410	✓		Rad gauge	
R.50	+/- .030	.500	✓			
1.22	+/- .030	1.220	✓			
R.50	+/- .030	.500	✓		Rad gauge	
.03X45°	+/- .030 X .5°	.030	✓			
1.10	+/- .030	1.100	✓			
.550	+/- .010	.550	✓			
1.18	+/- .030	1.180	✓			
.49	+/- .030	.4875	✓			
R.13	+/- .030	.125	✓		Rad gauge	
.125	+/- .010	.125	✓			
.20	+/- .030	.186	✓			
30°	+/- .5°	30°	✓			
1.150	+/- .005	1.151	✓			
.600	+/- .010	.596	✓			
45°	+/- .5°	45°	✓			
Ø .098	+ .004/- .001	.097	✓			
.17	+/- .030	.170	✓			
7/16-20 UNF	—	7/16-20	✓		Thread gauge	
.63 Deep	+/- .030	.630	✓			
7/16-20 UNF	—	7/16-20	✓		Thread gauge	

Measured by: 20	Checked by:	QC Inspector:
Date: 19-02-20	Date:	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

